

Date: Monday, 11/21/2005 1:54:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 24885		
Estimate Number	: 10845		
P.O. Number	: N/A	Part Number	: D32833
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Number	: D3283 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: See comment below	Due Date	: 12/10/2005
Checked & Approved By	: See comment below	Qty:	20 Um: Each
Comment	: Est A 04.09.28 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.2984 sf(s)/Unit Total : 5.9682 sf(s)
 6061-T6 .080 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.080" thick.
 (M6061T6S.080)
 Identify for D3283-3

Batch: *M6973*
119295

2.0	SHEAR	SHEAR
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Comment: SHEAR *50.2430*
 Cut blanks: 15.500" x 2.000"

J.L 05.12.15 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA424 and Dwg D3283
 Stack of 10
 Identify as D3283-3

J.L 05.12.15 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05.12.15 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EP 05/12/15 20

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DQUBLER

Job Number: 24885

Part Number: D32833

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FF 05/12/20

(110)

20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FF 05-12-21

20

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 411

06/01/03

20

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/04 (20)

06/01/04 (20)

Job Completion





FF 05-12-21

6.1

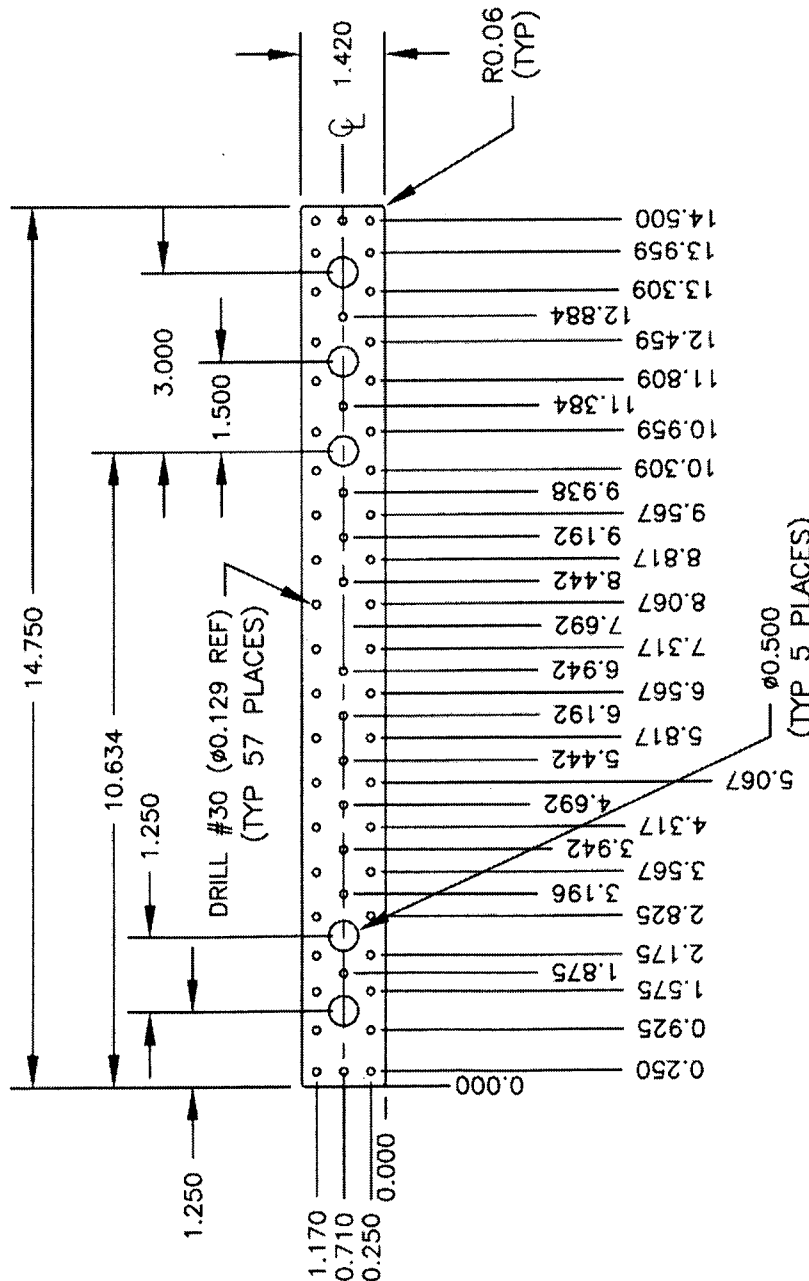
Acid: Alodine as per QSI as 4.1 as per Dwg 03283.

FF 05/12/21

20

DESIGN CP		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D3283	
DATE 05.08.09		TITLE DOUBLER		REV. D SHEET 1 OF 2	
A		04.05.06		NEW ISSUE	
B		04.08.09		10.882 WAS 11.502	
C		05.03.16		CHANGE HOLE PATTERN FOR -1	
D		05.08.09		REDESIGN	

RELEASED
05-09-06 #



~~D3283-1 DOUBLER~~

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

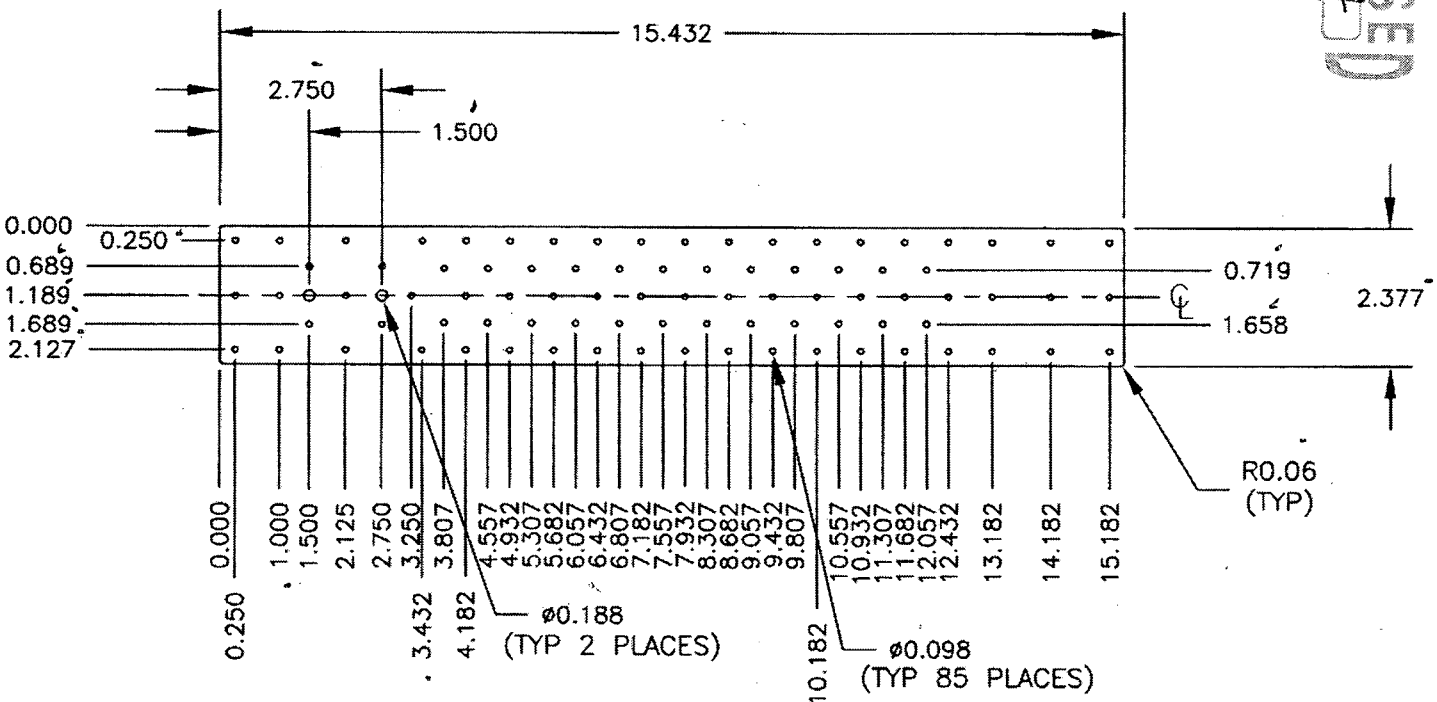
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DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3283	REV. D
		TITLE	DOUBLER	SHEET 2 OF 2
				SCALE
				1:3

RELEASED
05 09 06

**D3283-3 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	: 0024885	Department Code:	
Project Name	: D3283-3	Burden Flags	: NNNNNNNN
Project For	: WK549	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3283-3	Invoice Number	:
Description	: Doubler	Invoice Amount	: 0.00
Manufactured	: No	Order Entry No	:
Amount Req'd	: 0	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 11-18-05	Actual Margin	: 0.000%
Est Finish Date	:		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order: 24885
Description: Doubler		Part Number: 03283-3
Inspection Dwg: 03283 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.377	$\pm .010$	2.375	✓			
15.432	"	15.432	✓			
.719	"	.718	✓			
1.658	"	1.658	✓			
5.060	$\pm .030$.060	✓			
φ.098	$\pm .005$ $\pm .001$.101	✓			
φ.188						
2.750	$\pm .010$	2.749	✓			
1.500	"	1.499	✓			
.250	"	.250	✓			
.689	"	.688	✓			
1.189	"	1.189	✓			
1.689	"	1.689	✓			
2.127	"	2.127	✓			
.250	"	.249	✓			
1.000	"	.998	✓			
3.432	"	3.432	✓			

Measured by: J.L.	Audited by: J.G.	Prototype Approval:
Date: 05.12.15	Date: 05/12/15	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
05-12-21	6.0 6.1	Parts need to get Alodine'd as per Dwg. Add to I.R.P. Permanant Honey 2		05-12-21		4	2 05-12-21	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries